



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**C45-10-2**  
**Job Sheet 185263**



Part No: C45-10-2

Job Qty: 10 ea

Part Name: Lock Spring



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *Stk*

Description:

Note: DWG C45-10-2 Rev 3A IPP Rev A 18.02.08 New issue DP Verify DD

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off           |
|-------|--------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|--------------------|
|       |                    |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                    |
| 90    | Start up Operation | 10 Ea  |            | 11/9/18  | 0.00      | 0.00    | Start Up Small Fab-4  |           | <i>SB</i>          |
| 100   | Small Fab          | 10 pcs |            | 11/9/18  | 0.08      | 0.50    | Small Fab-9           |           | <i>M.L.</i>        |
| 110   | QC                 | 10 pcs |            | 11/9/18  | 0.00      | 0.00    | QC5                   |           | <i>SB</i>          |
| 130   | Packaging          | 10 pcs |            | 11/9/18  | 0.00      | 0.00    | Packaging3-2          |           | <i>M.L.</i>        |
| 140   | QC21-SA            | 10 Ea  |            | 11/9/18  | 0.00      | 0.00    | QC21                  |           | <i>DEC 07 2018</i> |

Part Op 100 - CUT SPRING AND BEND ENDS AS PER DWG. "EYES" AT THE ENDS MUST BE 90 DEGREE TO EACH OTHER  
Descriptions: 130 - Identify and Stock

### Job BOM

| Part / Item | Component Name                    | Quantity            | Operation             | Container      |
|-------------|-----------------------------------|---------------------|-----------------------|----------------|
| 9665K85     | Extension Spring 1/4" x 0.026" SS | 1.2500 ft (.125 ea) | 90-Start up Operation | <i>S128374</i> |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | 9665K85        | 1        | 20        | 0         |

### Part Specifications

Specifications could not be found.



Container No: S135379



Part: C45-10-2

Job No: 185263

Serial No/Batch: S135379

Revision: 3A

Inspector:

Exp Date:

Instructions:

Date: 12/06/18

1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Plex 10/24/18 11:40 AM Dart.lajeunesse.marie

DAS  
70  
9-89



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                              |  |                                                                                                                                                                                    |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |  |                                                                                                                                                     |  |  |
|--------------------------------------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|-----------------------------------------------------------------------------------------------------------------------------------------------------|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ |  | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> |  | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |  |  |                                                                                                                                                     |  |  |
| Date : _____                                                 |  | Step #: _____                                                                                                                                                                      |  | QTY Effective : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |  | MRB (QSI042) Approval<br><br><br>Completed By<br><br><br>Lead hand / Supervisor<br>Approval Verification<br><br><br>QC / QA Coordinator<br>Approval |  |  |
| Description Work Order Deviation                             |  |                                                                                                                                                                                    |  | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |  |                                                                                                                                                     |  |  |
|                                                              |  |                                                                                                                                                                                    |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |  |                                                                                                                                                     |  |  |
|                                                              |  |                                                                                                                                                                                    |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |  |                                                                                                                                                     |  |  |

| Root Cause                                  |  |                                                |  | FAULT CATEGORY                                  |  |                                                            |  |
|---------------------------------------------|--|------------------------------------------------|--|-------------------------------------------------|--|------------------------------------------------------------|--|
| Environment <input type="checkbox"/>        |  | No Re-verification <input type="checkbox"/>    |  | Pressure/Forced <input type="checkbox"/>        |  | Temperature/Cure <input type="checkbox"/>                  |  |
| Design <input type="checkbox"/>             |  | Operator <input type="checkbox"/>              |  | Bending <input type="checkbox"/>                |  | Set-up <input type="checkbox"/>                            |  |
| Doc/Data <input type="checkbox"/>           |  | Offset/Setup <input type="checkbox"/>          |  | Centre Not Concentric <input type="checkbox"/>  |  | BOM/Route <input type="checkbox"/>                         |  |
| Equip/Tooling <input type="checkbox"/>      |  | Supplier <input type="checkbox"/>              |  | Cracks <input type="checkbox"/>                 |  | Broken/Damage/Defect <input type="checkbox"/>              |  |
| Handling/Pre <input type="checkbox"/>       |  | Training <input type="checkbox"/>              |  | Crimp/Kink/Ripple/Wave <input type="checkbox"/> |  | Inspection Incomplete/Unqualified <input type="checkbox"/> |  |
| Material <input type="checkbox"/>           |  | Use for Testing <input type="checkbox"/>       |  | Cuffs <input type="checkbox"/>                  |  | Contamination <input type="checkbox"/>                     |  |
| Internal Transport <input type="checkbox"/> |  | Poor Information <input type="checkbox"/>      |  | Crushing <input type="checkbox"/>               |  | Countersink <input type="checkbox"/>                       |  |
| Tribal Knowledge <input type="checkbox"/>   |  | Rushing <input type="checkbox"/>               |  | Heat Treat <input type="checkbox"/>             |  | Cut Too Short <input type="checkbox"/>                     |  |
| LOA <input type="checkbox"/>                |  | Product Improvement <input type="checkbox"/>   |  | Wave/Twist in Tube <input type="checkbox"/>     |  | Instructions Incomplete/Unclear <input type="checkbox"/>   |  |
| Substation <input type="checkbox"/>         |  | Process Improvement <input type="checkbox"/>   |  | Marks/Chatter <input type="checkbox"/>          |  | Drill Holes <input type="checkbox"/>                       |  |
| Past Expiry Date <input type="checkbox"/>   |  | Manufacturing Process <input type="checkbox"/> |  | OTHER : _____                                   |  |                                                            |  |
| Misidentified <input type="checkbox"/>      |  | Past Due <input type="checkbox"/>              |  |                                                 |  |                                                            |  |

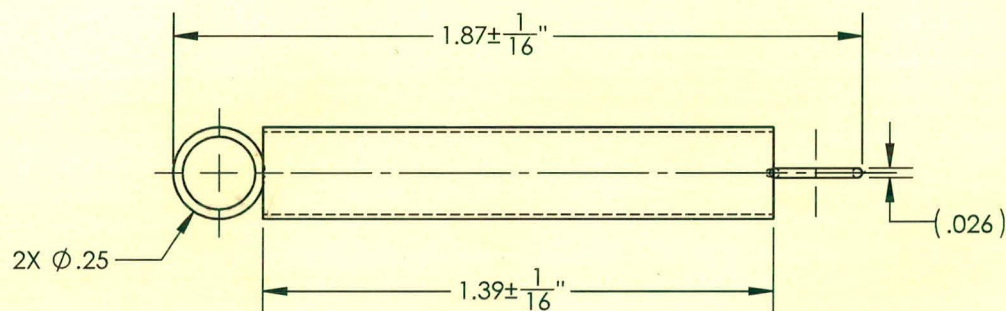






This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

| REVISIONS |         |                                                                |            |         |          |
|-----------|---------|----------------------------------------------------------------|------------|---------|----------|
| REV       | ECR     | DESCRIPTION                                                    | DATE       | INITIAL | APPROVED |
| 2         |         | AS DRAWN BY CANAM.                                             | 9/13/2012  | JAG     |          |
| 3         |         | CORRECTED COIL LENGHT FROM 1.65 TO 1.39 ADDED TOLERANCES.      | 10/31/2012 | JAG     |          |
| 3A        | 14-0127 | CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED BAG & LABEL NOTE. | 8/14/2014  | DPD     | RW       |



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 185263 MWS  
181024

#### NOTES:

1. THE "EYES" AT THE ENDS MUST BE 90° TO EACH OTHER.
2. BAG & LABEL WITH BATCH NUMBER.

|                                                                                                                            |                        |
|----------------------------------------------------------------------------------------------------------------------------|------------------------|
| <b>DART<br/>AEROSPACE</b>                                                                                                  |                        |
| TITLE<br><b>LOCK SPRING C45-HOOK</b>                                                                                       |                        |
| DWG NO.<br><b>C45-10-2</b>                                                                                                 | REV<br><b>3A</b>       |
| MAT'L 302 S.S.                                                                                                             | DRAWN BY: CANAM        |
| UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES<br>.XXX ± .005 FRACTIONS ± 1/8<br>.XX ± .01 ANGLES ± .5°<br>.X ± .1 | APPROVED <i>D Weil</i> |
| 1. BREAK ALL SHARP EDGES .015 x 45°<br>OR .015R                                                                            | HEAT TREAT             |
| 2. DIMENSIONAL LIMITS APPLY AFTER PLATING                                                                                  | FINISH                 |
|                                                                                                                            | SPEC                   |
|                                                                                                                            | USED ON MODEL          |
| SCALE 2:1                                                                                                                  | DATE 9/21/2004         |
| SHEET 1 OF 1                                                                                                               |                        |

| ASSY QTY | ASSY QTY | B/O | Part #   | UNIT QTY | Description          | Material | B/O INFORMATION OR SPECIFICATIONS                      |
|----------|----------|-----|----------|----------|----------------------|----------|--------------------------------------------------------|
|          |          |     | C45-10-2 | 1        | LOCK SPRING C45 HOOK | 302 S.S. | Ø.25 OD X Ø.026 WIRE MCMASTER-CARR #9665K85 (MODIFIED) |

